

Work Order ID 80630

February-24-12 3:20:35 PM

80630

Page 1

Item ID: D4022-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Transfer Pump Assembly
 Start Date: 24/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 09/03/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 24/02/27 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4022	B

100 0.00

100

Small Fab Memo 0.00

Small Fab Assemble as per dwg D4022

Metal set A4 batch: M116173

O-ring Lub as per dwg batch: M118340

110 QC5- Inspect part completeness to step on W/O 0.00

110

QC Memo 0.00

Quality Control

2 ϕ FF 12-05-08
 42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

Identify as per dwg & Stock Location: 143

0.00

120

Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/5/10 DJ

mf
12-05-09

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Picklist Print

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Page 1
[Signature]

Work Order ID: 80630

80630

Parent Item: D4022-041

D4022-041

Parent Item Name: Fuel Transfer Pump Assembly

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.02.02 new issue Prelim EC verified by:DD IPP Rev:B
10.05.17 as per ECN10-562 DD verf:EC IPP REV:C 11.11.22
PER ECN11-665 DD VERF:EC IPP REV:D 12.02.08 replace
AN818-6D for AN815-6D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4022-1 *D4022-1* Fuel Transfer Pump		Manufactured	No			100	Each	1.0000	1	4			
										**	(2)	FF 12-05-08	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST143	82963<	1					
						75583		1					
D4022-5 *D4022-5* Thermal Switch		Manufactured	No			100	Each	43.0000	1	4			
										**	(2)	FF 12-05-08	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST083		40					
						79949		40					
						ST110		3					
						75585		3					
AN815-6D *AN815-6D* Union-M-Flare		Purchased	No			100	Each	30.0000	2	8			
										**	(2)	FF 12-05-08	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST325	121390	30					
						119396		8					
						119433		2					
						119438		20					

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 80630

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Parent Item: D4022-041

D4022-041

Parent Item Name: Fuel Transfer Pump Assembly

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 4.00

Required Qty: 4.00

MS29512-06

Purchased

No

100

Each

33.0000

2

8

MS29512-06

O-RING

**

② FF 12-05-08

Location

Loc Qty

Loc Code

ST293

121166

33

120123

13

120360

20

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

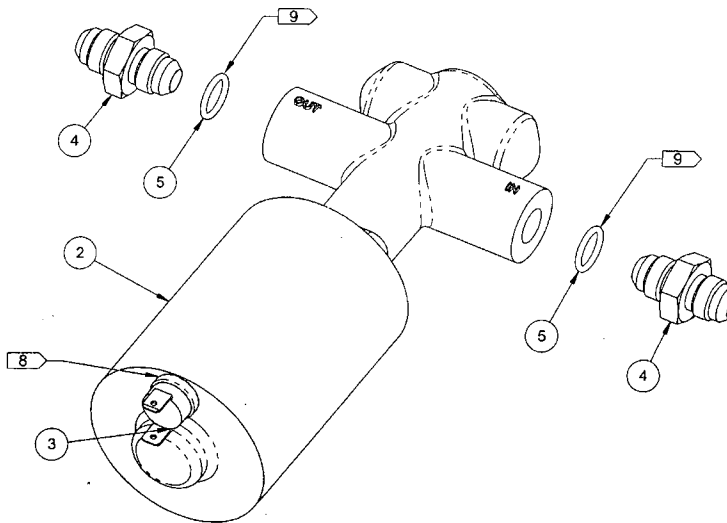
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4022-041	FUEL TRANSFER PUMP ASSEMBLY	A8150-B1-JCA
2	1	D4022-1	FUEL TRANSFER PUMP	
3	1	D4022-5	THERMAL SWITCH	
4	2	AN818-6D	FITTING, UNION	
5	2	MS29512-06	O RING	



D4022-041 FUEL TRANSFER PUMP ASSEMBLY

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80630-M.C.J
12/02/27

RELEASED
2011-11-16

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4022-041" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.61 lbs
 - 8) ATTACH D4022-5 THERMAL SWITCH TO D4022-1 FUEL PUMP IN LOCATION SHOWN USING METALSET A4
 - 9) LUBRICATE O-RING WITH ULTRACHEM ASSEMBLY FLUID #1, FUEL-LUBE, MOLYKOTE 55 O-RING GREASE OR EQUIVALENT

B	CORRECTED SPELLING OF "AEROSPARES"	DC	11.09.28
A	NEW ISSUE	HS	10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DC		
DRAWN	DC		
CHECKED	DC		
MFG. APPR.			
APPROVED	160		
DE APPR.			
DATE	11.09.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4022** REV. B
SHEET 1 OF 4

TITLE **FUEL PUMP** SCALE NTS

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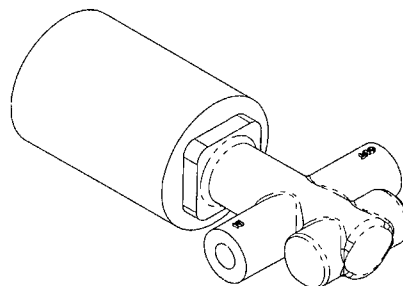
NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER

D4022-1

JOHN CAMERON AVIATION
PART NUMBER

REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING

DART PART NUMBER	SUPPLIER	SUPPLIER PART NUMBER	OPERATING VOLTAGE	FLOW (GPH)	OUTPUT PRESSURE (PSI)	TEMPERATURE RANGE
D4022-1	WELDON	A8150-B1	24 VDC	35 - 50	5 - 25	-65°F TO +185°F
	AEROSPARES ACCESSORIES	A8150-B1	24 VDC	35 - 50	5 - 25	-65°F TO +185°F

**D4022-X FUEL TRANSFER PUMP****NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.6 lbs

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.		D4022	SHEET 2 OF 4
APPROVED	AD	TITLE	SCALE
DE APPR.	#	FUEL PUMP	NTS
DATE	11.09.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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2011-11-16
JMP

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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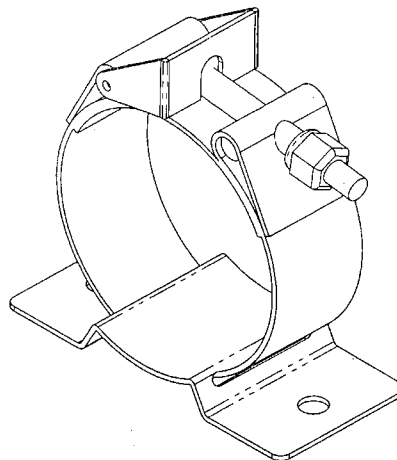
DART AEROSPACE
PART NUMBER

D4022-3

JOHN CAMERON AVIATION
PART NUMBER

REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	FITS MOTOR SIZE (ϕ)
D4022-3	WELDON	TC 250-100	STAINLESS STEEL	2.5
	AIRCRAFT SPRUCE AND SPECIALTY	05-00021	STAINLESS STEEL	2.5
	AEROSPACE ACCESSORIES	TC 250-100	STAINLESS STEEL	2.5

D4022-X FUEL PUMP MOUNTING BRACKET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4022	SHEET 3 OF 4
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2011-11-16

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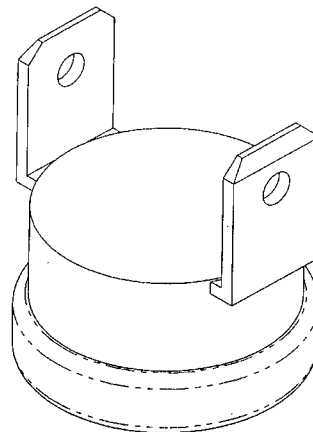
NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER

D4022-5

JOHN CAMERON AVIATION
PART NUMBER

REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING

DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	ALTERNATE PART NUMBER	TEMPERATURE WHEN SWITCH OPENS
D4022-5	FARNELL	1006847	3775628	125°F
	HONEST-WELL	T23A125BSR2-15	3775628	125°F
	NEWARK	98K1992	3775628	125°F

D4022-X THERMAL SWITCH**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D4022	REV. B
MFG. APPR.		TITLE FUEL PUMP	SHEET 4 OF 4 SCALE NTS
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